

~~DUPPLICATE~~

Dart Aerospace Ltd.

Date: Friday, 6/1/2007 1:02:30 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARSHOE		
Job Number	: 32738		Part Number	: D35645		
Estimate Number	: 12786		Drawing Number	: D3564 UNDER REVIEW		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 6/1/2007	S.O. No. : N/A	Drawing Revision	: ABC PH 07.07.12		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 6/8/2007 Qty: 20 Um: Each		
Previous Run	: 31420					
Written By						
Checked & Approved By						
Comment	: Est Rev:A New Issue 07-03-08 ec					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet
<p>Comment: Qty.: 1.1099 sf(s)/Unit Total : 22.1970 sf(s) HB 07-07-19</p> <p>M304S16GA Stainless steel sheet 0.063" thick</p> <p>Batch: M 103963 M 103961 M 101873</p>		
2.0	WATER JET	FLOW WATER JET
<p>Comment: FLOW WATER JET</p> <p>1-Cut as per Dwg D3564 + (D3564-SF) PH 07.07.12</p> <p>Dwg Rev: C</p> <p>Prog Rev: C HB 07-07-19</p>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</p> <p>HB 07-07-19</p>		
4.0	QC8	SECOND CHECK
<p>Comment: SECOND CHECK</p> <p>HB 07-07-19</p>		
5.0	BRAKE NC	NC BRAKE
<p>Comment: NC BRAKE</p> <p>Deburr if necessary</p> <p>Form on Brake as per Dwg D3564 using Jigs DT 3155 and DT 3170</p> <p>Form Joggle as per Dwg D3564 on brake using Jig DT</p>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/07/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/07/03	S	Foggle was made by error						

NOTE: Date & initial all entries

Date: Friday, 6/1/2007 1:02:30 PM
User: Kim-Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 32738

Part Number: D35645

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

Sp 07/07/20 *(X23)* counter

7.0 POWDER COATING

POWDER COATING



M 104846



(Q3X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M-L 07/07/20

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



M-L 07/07/21



(23)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



(Q3X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-14

M-L 07/07/23

10.0 QC21

FINAL INSPECTION/W/O RELEASE



(23)

Comment: FINAL INSPECTION/W/O RELEASE

R 06/07/23

Job Completion



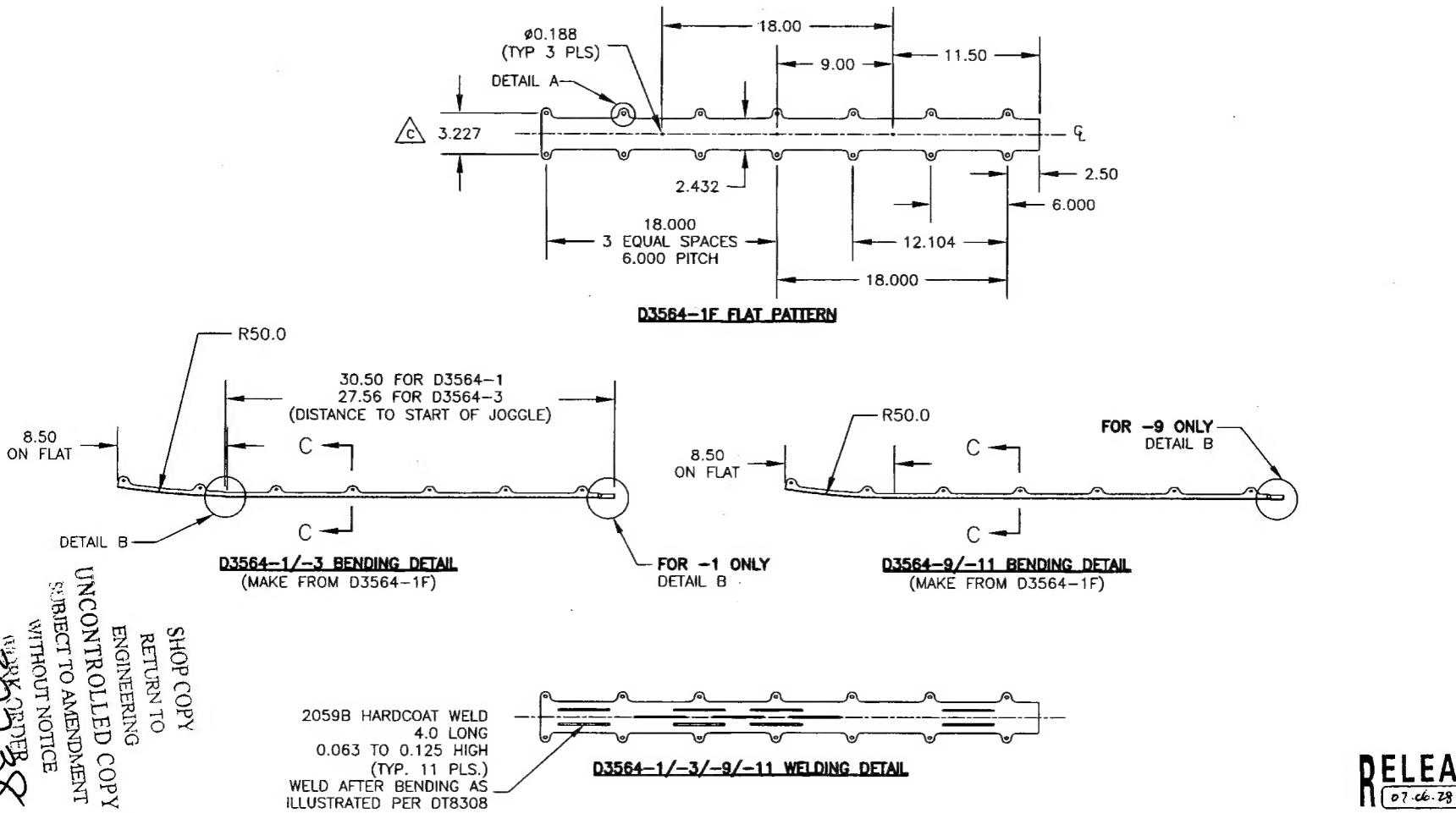
U 07.07.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

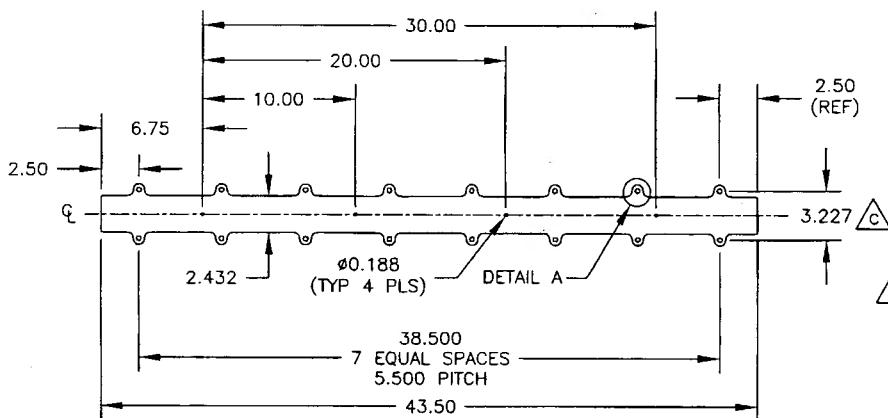


D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES

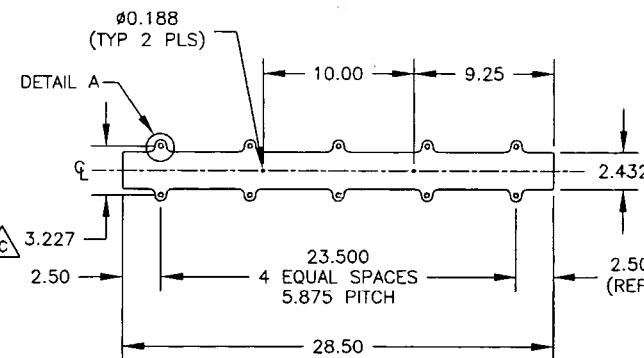
- MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- WELD PER DART QSI 004
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- BREAK ALL SHARP EDGES 0.005 TO 0.015
- PART IS SYMMETRICAL ABOUT CENTERLINE

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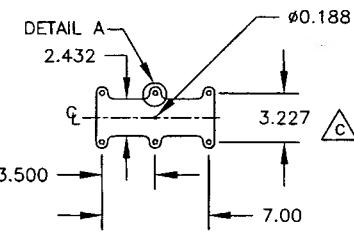
DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HANCOCK, ONTARIO, CANADA
CHECKED	APPROVED		DRAWING NO. D3564
			REV. C SHEET 1 OF 2
DATE		TITLE	WEARSHOE
07.04.17		SCALE	1:8



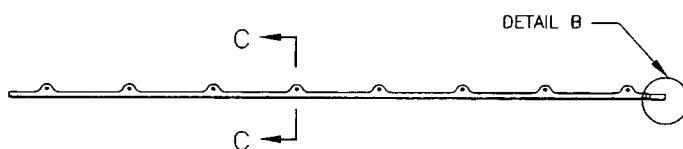
D3564-5F FLAT PATTERN



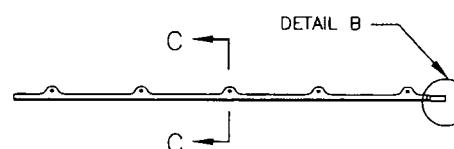
D3564-7F FLAT PATTERN



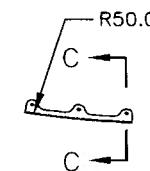
D3564-13F FLAT PATTERN



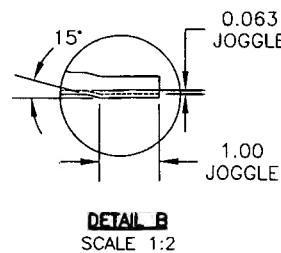
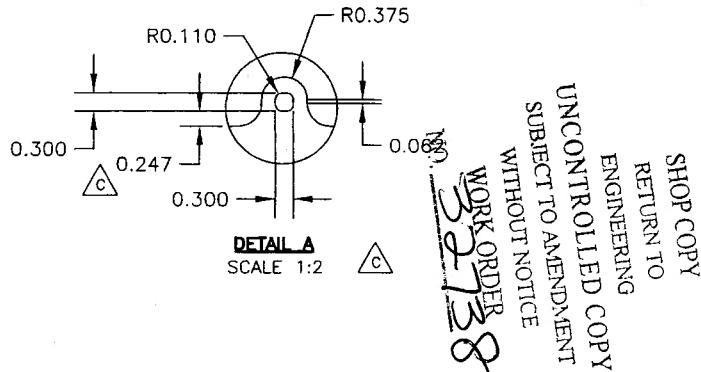
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



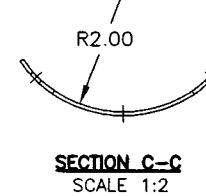
D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



DETAIL B
SCALE 1:2



SECTION C-C
SCALE 1:2

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	DATE 07.04.17	TITLE WEARSHOE		1:8

RELEASED
07.06.28/11

DART AEROSPACE LTD	Work Order:	32738
Description: WEAR SHOE	Part Number:	D3564-5
Inspection Dwg:	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

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First Article

1

Prototype

Measured by:	RB
Date:	07-07-18

Audited by:	Ess
Date:	07/07/2009

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	